



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312
Job Sheet 180461



Part No: D350-591-312

Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



D350-591-312

Part Weight: 0 lbs

Status: Scheduled

REV. 5 Priority: Medium

Job Created: 7/6/18

Job Tracking No:

Due Date: 9/6/18

Created By: Marie Lajeunesse **S104775**

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	9/6/18	9/6/18	0.00	0.00	Start Up Large Fab-4		
110	Large Fab	10 pcs	9/6/18	9/6/18	0.00	10.00	Large Fab 2		
120	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC9		
130	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC5		
140	HandFinish	10 pcs	9/6/18	9/6/18	0.00	1.87	HandFinish1		
150	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC7-2		
180	Large Fab	10 pcs	9/6/18	9/6/18	0.00	10.00	Large Fab 2		
190	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC10		
200	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC5		
210	HandFinish	10 pcs	9/6/18	9/6/18	0.00	1.87	HandFinish1		
220	Powdercoat	10 pcs	9/6/18	9/6/18	0.00	2.98	Powdercoat1		
230	HandFinish	10 pcs	9/6/18	9/6/18	0.00	1.87	HandFinish3		
240	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC3		
250	Packaging	10 pcs	9/6/18	9/6/18	0.00	0.00	Packaging1-3		
260	QC	10 pcs	9/6/18	9/6/18	0.00	0.00	QC4		
270	Packaging	10 pcs	9/6/18	9/6/18	0.00	0.00	Packaging3-1		
275	DC	10 pcs	9/6/18	9/6/18	0.00	0.00	DC		
280	QC21-FG	10 Ea	9/6/18	9/6/18	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Descriptions: Dwg D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 11:50 OVEN TEMPERATURE: 520° FINISH TIME: 12:20 D.

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	5090880
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	5091443
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5094261
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	5102504

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging
D2618	Bushing	20 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging

SD88668
5079116

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	133	0
	D3219-1	20	123	0
	D3272-1	10	25	0
180-Large Fab	D3065-041	10	18	0
	D3066-1	20	178	0
	MS20600-AD4W4	160	3,204	0
250-Packaging	AN3-35A	20	380	0
	AN4-13A	80	2,267	0
	AN5-36A	20	324	0
	D2230-3	40	333	0
	D2618	20	220	0
	D2856-400-720	20	74	0
	D3235-1	20	117	0
	D3278-041	10	42	0
	MS21042L3	20	2,128	0
	MS21042L4	80	3,302	0
	MS21042L5	20	922	0
	NAS1149D0363J	40	1,662	0
	NAS1149D0463J	160	7,409	0
	NAS1149D0563J	40	1,662	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube</td><td style="width:15%;">Cross tube</td><td style="width:15%;">Water Jet</td><td style="width:15%;">Engineering</td></tr> <tr> <td>Machining</td><td>Small Fab</td><td>Prod. Eng. Coord.</td><td>Quality</td></tr> <tr> <td>Thermoforming</td><td>Finishing</td><td>Rec/Store/Packaging</td><td>Other</td></tr> <tr> <td>Large Fab</td><td>Composite</td><td>Supplier</td><td></td></tr> </table>						Skid-tube	Cross tube	Water Jet	Engineering	Machining	Small Fab	Prod. Eng. Coord.	Quality	Thermoforming	Finishing	Rec/Store/Packaging	Other	Large Fab	Composite	Supplier																																														
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Date : _____		Step #: _____		Instructions: TC STC SH92-6 Issue 1d, F&A STC SH967NE 04/12/21, BRAZIL 1 Revision: _____ Inspector: _____ Exp Date: _____ Part: D350-591-312 Job No: 180461 Serial No/Batch: S104775 DART AEROSPACE Container No: S104775 1270 Aberdeen Street Haverhill, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																																		
Description Work Order De _____																																																																						
Root Cause <table style="width:100%; border: none;"> <tr><td>Environment</td><td>No Re-verification</td></tr> <tr><td>Design</td><td>Operator</td></tr> <tr><td>Doc/Data</td><td>Offset/Setup</td></tr> <tr><td>Equip/Tooling</td><td>Supplier</td></tr> <tr><td>Handling/Pre</td><td>Training</td></tr> <tr><td>Material</td><td>Use for Testing</td></tr> <tr><td>Internal Transport</td><td>Poor Information</td></tr> <tr><td>Tribal Knowledge</td><td>Rushing</td></tr> <tr><td>LOA</td><td>Product Improvement</td></tr> <tr><td>Substation</td><td>Process Improvement</td></tr> <tr><td>Past Expiry Date</td><td>Manufacturing Process</td></tr> <tr><td>Misidentified</td><td>Past Due</td></tr> </table>		Environment	No Re-verification	Design	Operator	Doc/Data	Offset/Setup	Equip/Tooling	Supplier	Handling/Pre	Training	Material	Use for Testing	Internal Transport	Poor Information	Tribal Knowledge	Rushing	LOA	Product Improvement	Substation	Process Improvement	Past Expiry Date	Manufacturing Process	Misidentified	Past Due	<table style="width:100%; border: none;"> <tr><td>Pre</td><td>Cracks</td><td>Broken/Damage/Defect</td></tr> <tr><td>Ben</td><td>Crimp/Kink/Ripple/Wave</td><td>Inspection Incomplete/Unqualified</td></tr> <tr><td>Cer</td><td>Cuffs</td><td>Contamination</td></tr> <tr><td></td><td>Crushing</td><td>Countersink</td></tr> <tr><td></td><td>Heat Treat</td><td>Cut Too Short</td></tr> <tr><td></td><td>Wave/Twist in Tube</td><td>Instructions Incomplete/Unclear</td></tr> <tr><td></td><td>Marks/Chatter</td><td>Drill Holes</td></tr> </table>		Pre	Cracks	Broken/Damage/Defect	Ben	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Cer	Cuffs	Contamination		Crushing	Countersink		Heat Treat	Cut Too Short		Wave/Twist in Tube	Instructions Incomplete/Unclear		Marks/Chatter	Drill Holes	<table style="width:100%; border: none;"> <tr><td>Positioned Wrong</td><td>Wrong Stock Pulled</td></tr> <tr><td>Outside Dimensions</td><td>Out of Sequence</td></tr> <tr><td>Over/Under tolerance</td><td>Off-set</td></tr> <tr><td>Part Incorrect</td><td>Mislabeled</td></tr> <tr><td>Part Lost/Missing</td><td>Fit/Function</td></tr> <tr><td>Part Moved</td><td>Misaligned/off center</td></tr> <tr><td>Drawing</td><td></td></tr> <tr><td>Finish</td><td></td></tr> <tr><td>Misread</td><td></td></tr> <tr><td>Turning Sequence</td><td></td></tr> </table>		Positioned Wrong	Wrong Stock Pulled	Outside Dimensions	Out of Sequence	Over/Under tolerance	Off-set	Part Incorrect	Mislabeled	Part Lost/Missing	Fit/Function	Part Moved	Misaligned/off center	Drawing		Finish		Misread		Turning Sequence	
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Tel (613) 632-5200

D350-591-312
Job Sheet 180461



Click bus
004922

Part No: D350-591-312

Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/6/18

Job Tracking No:

Due Date: 9/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		9/6/18	0.00	0.00	Start Up Large Fab-4		
110	Large Fab	10 pcs		9/6/18	0.00	10.00	Large Fab 2		
120	QC	10 pcs		9/6/18	0.00	0.00	QC9		
130	QC	10 pcs		9/6/18	0.00	0.00	QC5		
140	HandFinish	10 pcs		9/6/18	0.00	1.87	HandFinish1		
150	QC	10 pcs		9/6/18	0.00	0.00	QC7-2		
180	Large Fab	10 pcs		9/6/18	0.00	10.00	Large Fab 2		
190	QC	10 pcs		9/6/18	0.00	0.00	QC10		
200	QC	10 pcs		9/6/18	0.00	0.00	QC5		
210	HandFinish	10 pcs		9/6/18	0.00	1.87	HandFinish1		
220	Powdercoat	10 pcs		9/6/18	0.00	2.98	Powdercoat1		
230	HandFinish	10 pcs		9/6/18	0.00	1.87	HandFinish3		
240	QC	10 pcs		9/6/18	0.00	0.00	QC3		
250	Packaging	10 pcs		9/6/18	0.00	0.00	Packaging1-3		
260	QC	10 pcs		9/6/18	0.00	0.00	QC4		
270	Packaging	10 pcs		9/6/18	0.00	0.00	Packaging3-1		
275	DC	10 pcs		9/6/18	0.00	0.00	DC		
280	QC21-FG	10 Ea		9/6/18	0.00	0.00	QC21		

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AUG 02 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Descriptions: Dwg D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush
180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.
220 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072
275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	

AND S. D. GUA

D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging
D2618	Bushing	20 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging
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 5058728
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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	133	0
	D3219-1	20	123	0
	D3272-1	10	25	0
180-Large Fab	D3065-041	10	18	0
	D3066-1	20	178	0
	MS20600-AD4W4	160	3,204	0
250-Packaging	AN3-35A	20	380	0
	AN4-13A	80	2,267	0
	AN5-36A	20	324	0
	D2230-3	40	333	0
	D2618	20	220	0
	D2856-400-720	20	74	0
	D3235-1	20	117	0
	D3278-041	10	42	0
	MS21042L3	20	2,128	0
	MS21042L4	80	3,302	0
	MS21042L5	20	922	0
	NAS1149D0363J	40	1,662	0
	NAS1149D0463J	160	7,409	0
	NAS1149D0563J	40	1,662	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200
Fax 613 632-5246

Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004822	S098686	AN3-35A	Bolt	s089307	ST348	20
004822	S098684	AN4-13A	Bolt	S089302	OVER003	80
004822	S098683	AN5-36A	Bolt	s083019	ST336	20
004822	S098707	D2618	Bushing	S082275	ST008	20
004822	S092667	D2856-400-720	Abrasion Strip 4" X 7.20"	S092661 S0926	ST418	15
004822	S098706	D2856-400-720	Abrasion Strip 4" X 7.20"	S098273	ST418	5
004822	S098674	D3235-1	Mounting Lug	S089615	ST522	20
004822	S098671	D3278-041	Support Assembly	S092091	ST522	10
004822	S098668	MS21042L3	Nut	s089340	ST303	20
004822	S098665	MS21042L4	Nut	s089365	ST303	80
004822	S098630	MS21042L5	Nut	s058178	ST303	20
004822	S098625	NAS1149D0363J	Washer	s068661	ST263	40
004822	S098622	NAS1149D0463J	Washer	s089299	ST263	160
004822	S098614	NAS1149D0563J	Washer	s093773	ST263	40

S092667

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

D2230-3

S103723 Qty 40

Plex 8/2/18 12:42 PM Dart.joly.jocelyne

Faint handwritten text, possibly "Faint" or "Faintly".

Faint handwritten text, possibly "Faintly".

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

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